Work Order ID 110394 - 2 SPLIT *110394* Page 1

December-18-13 8:50:12 AM

Item ID: D4635-1 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Fwd Ceiling Panel, LH

Start Date: 12/18/13 **Start Qty:** 2.00 *2* **Cust Item ID:**

Required Date: 12/31/13 **Req'd Qty:** 2.00 *2* **Customer:**

Reference:

Approvals: **Process Plan:** MLJ **Date:** 13-12-18 **Tooling:** _____ **Date:** _____ **Run Start** *NR1*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D4635	~~POT~~ PET Rev F	DAS 27 9-89 Rev ECN14-504							
100	HAND FINISHING THERMOFORMING	0.00							
100						~~2~~ 3			MJ 13/17/19
Thermoform	**Memo**	0.00							
Thermoforming Machine	Cut Blanks								
105	Dry Material	0.00							
105						~~2~~ 3			MJ 13/17/19
HandTherm	**Memo**	0.00							
Hand Finishing Thermoforming	Dry Sheet as per QSI022 KYDEX								

Temp: 245°F

Time IN: 700 AM 13/12/18

Time OUT: 700 AM (3/17/19

Item ID: D4635-1 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Fwd Ceiling Panel, LH

Start Date: 12/18/13 **Start Qty:** 2.00 *2*
Required Date: 12/31/13 **Req'd Qty:** 2.00 *2*
Reference:

Cust Item ID:
Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110		0.00							
110	THERMOFORMING MACHINE					2	1		DL 13/12/19
Thermoform	**Memo**	0.00							
Thermoforming Machine	Thermoform as per Dwg. D4635-1 and Folio FTA147								
	Dwg. Rev. P01								
	Folio Rev. D								
	Visually inspect for proper formation and texture								
130		0.00				1			B 14/12/19
130	HAND FINISHING THERMOFORMING					1			B 13/12/22
Thermoform	**Memo**	0.00							
Thermoforming Machine	Trim to Finished Dimensions								
140	QC2- Inspect parts off machine FAI/FAIB	0.00				x1			DL 13/12/22
140									
QC	**Memo**	0.00							
Quality Control									

DAS 27 9-89 14/1/16 WA

Item ID: D4635-1 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Fwd Ceiling Panel, LH

Start Date: 12/18/13 **Start Qty:** 2.00 *2*
Required Date: 12/31/13 **Req'd Qty:** 2.00 *2*
Reference:

Cust Item ID:
Customer:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	~~QC5- Inspect part completeness to step on W/O~~ 6	0.00				1			
150									
QC	**Memo**	0.00							
Quality Control									
160	Packaging	0.00				1	SAD	12/01/17	
160									
Packaging	**Memo**	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	**Memo**	0.00							
Quality Control									

DAS 27 9-89 12/12/23

DAS 27 9-89 14/1/16

Inspect as per Rev FD1

USE ON W/O B111196

MLJ 14-01-23

LL 12/2.23

MF 14-1-17

RD4397A

DAS 27 9-89 14/1/23

POSITIVE RECALL
EFFECTIVE 12/2/23 AUTH LL
RELEASED _____ DATE _____
Release Dwg Rev K

Picklist Print

December-18-13 8:50:16 AM

Work Order ID: 110394 *1110394*

Parent Item: D4635-1 *D4635-1*

Parent Item Name: Fwd Ceiling Panel, LH

Start Date: 12/18/13 **Required Date:** 12/31/13

Start Qty: 2.00 **Required Qty:** 2.00

Comments: IPP Rev. A New Issue 12/05/07 DL VERIFIED BY:JLM IPP Rev. B Dwg. Update 12/11/08 DL IPP Rev. C Dwg Update 13/07/09 DL IPP Rev D Dwg Update, Material Change 13/12/18 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.093-F6006-07		Purchased	No			100	sf	1,838.000	14.9	30			
MLEXS.093-F6006-07 GE PLASTICS LEXAN SHEET									**	30	30	13/12/23	

Location	Loc Qty	Loc Code
MAT023	2067.26	
114459	229.26	
123105	38	
124501	1800	

DART AEROSPACE LTD	Work Order:	110394
Description:	Part Number:	D4635-1
Inspection Dwg: PD1 Rev: PD1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than N/A "				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by:	DL	Date:	14/01/15

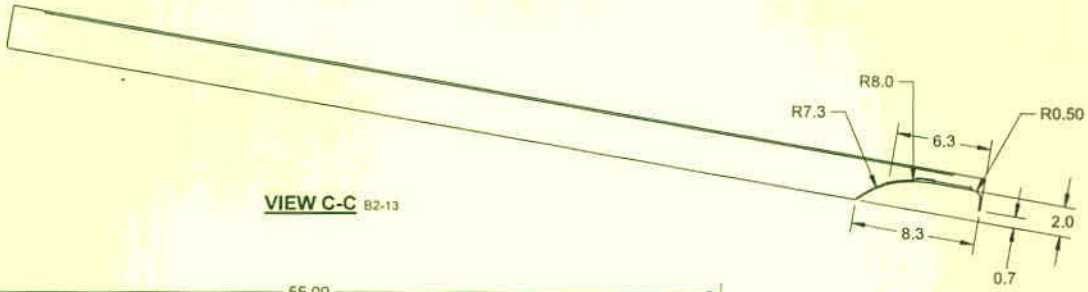
TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
65.75"		65.75"	✓			
15.46"		15.46"	✓			
Ø 3.50"		3.51"	✓			
Ø 2.03"		2.03"	✓			
Ø 0.196"		0.195"	✓			

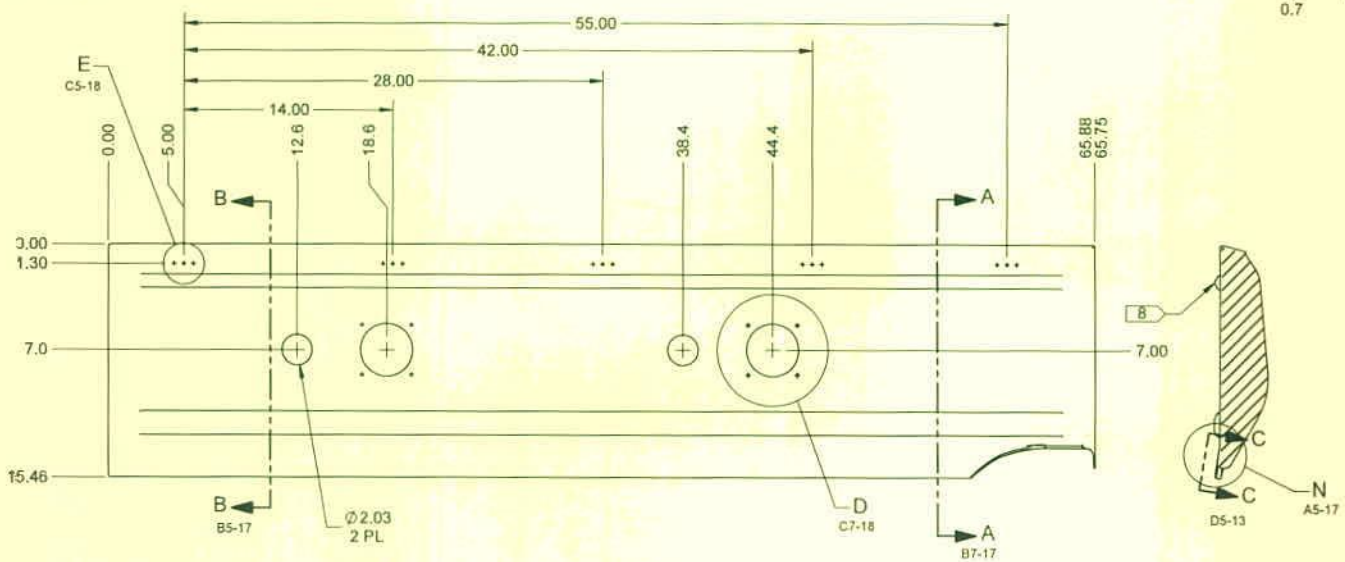
Measured by:	DL DAS	Date:	14/01/15
Audited by:	27 9-89	Date:	14/1/23
Preliminary Approval:		Date:	

Rev	Date	Change	Revised by	Approved
B	10.04.14	Added preliminary approval	KJ	

10.04.14



VIEW C-C B2-13



NOTES:
1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK
(REF DART SPEC MLEXS.093-F6006-07)
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 4.39 lbs
8) TEXTURE ON THIS SIDE
9) TRIM D4635-1 PER TOOL DT9839
10) THERMOFORM D4635-1 PER QSI 022 USING DT9847 TOOL
MIN. THICKNESS AFTER FORMING:
SHAPED AREA = 0.040
RIDGES/EDGES = 0.060
ELSEWHERE = 0.070

D4635-1 LH, FWD CEILING PANEL

DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED	BC	DRAWING NO. D4635 REV. PE1
MFG. APPR.		SHEET 13 OF 18
APPROVED		TITLE OUTBOARD CEILING PANELS SCALE NTS
DE APPR.		
DATE 14.01.09		

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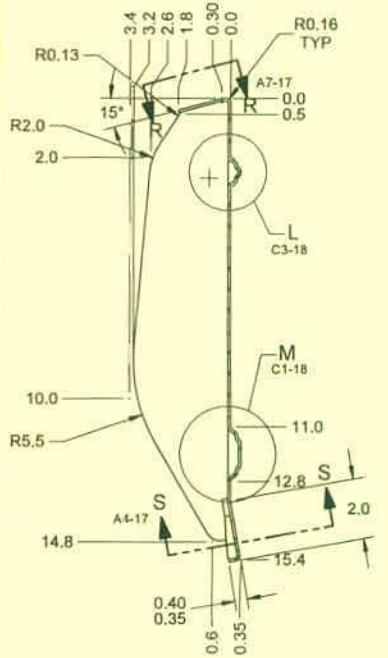
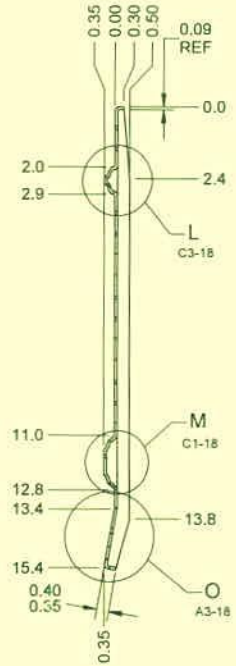


SECTION A-A
SECTION A'-A' OPPOSITE B3-13 B3-14
SCALE 2X



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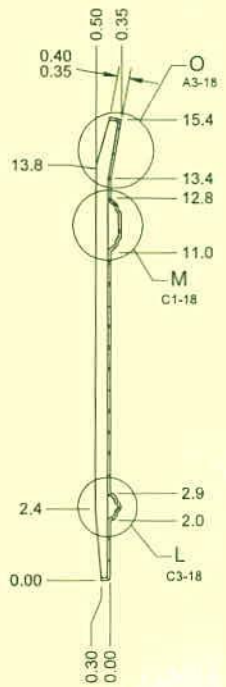

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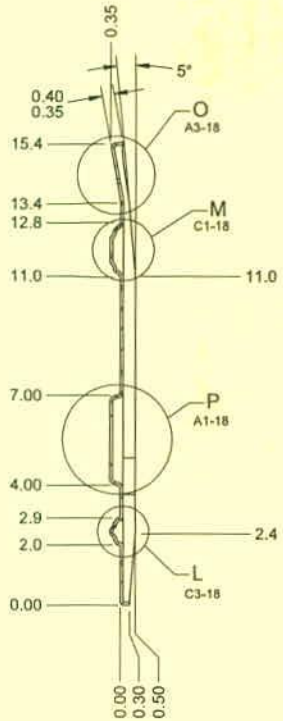
SCALE 2X



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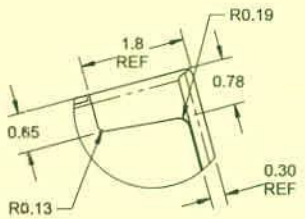
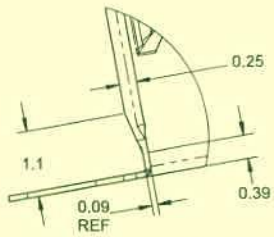
SCALE 2X



AUXILIARY VIEW R-R
SECTION R'-R' OPPOSITE D7-17
SCALE 2X



AUXILIARY VIEW S-S
SECTION S'-S' OPPOSITE B7-17
SCALE 2X

DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED	BC	DRAWING NO. D4635 REV. PE1
MFG. APPR.		SHEET 17 OF 18
APPROVED		TITLE OUTBOARD CEILING PANELS SCALE NTS
DE APPR.		
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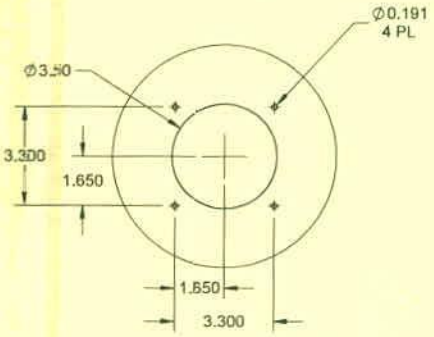

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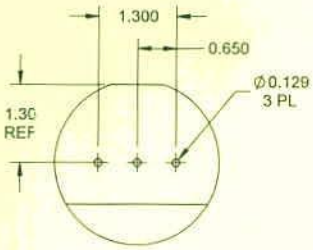

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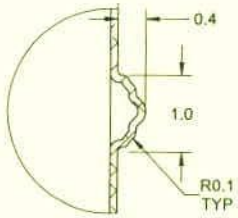

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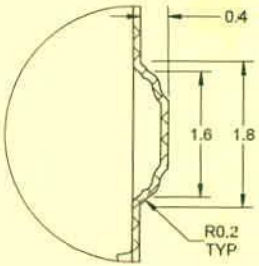

DETAIL M C2-17 C3-17 C5-17 C7-17
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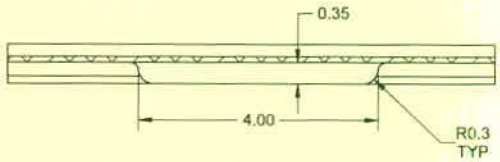

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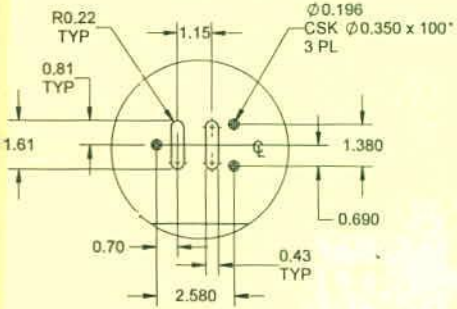

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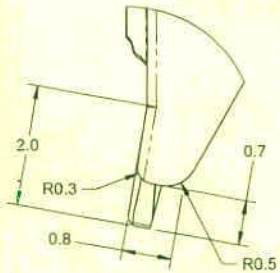

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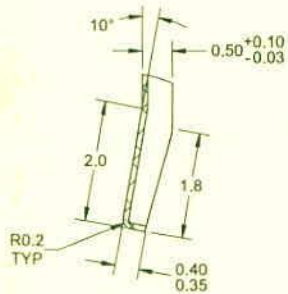
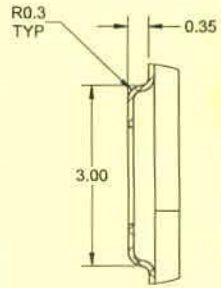


DETAIL O D2-17 D3-17 B5-17
SCALE 2X



DETAIL P C2-17
SCALE 4X

DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED	BC	DRAWING NO. D4635 REV. PE1
MFG. APPR.		SHEET 18 OF 18
APPROVED		TITLE OUTBOARD CEILING PANELS SCALE NTS
DE APPR.		
DATE	14.01.09	

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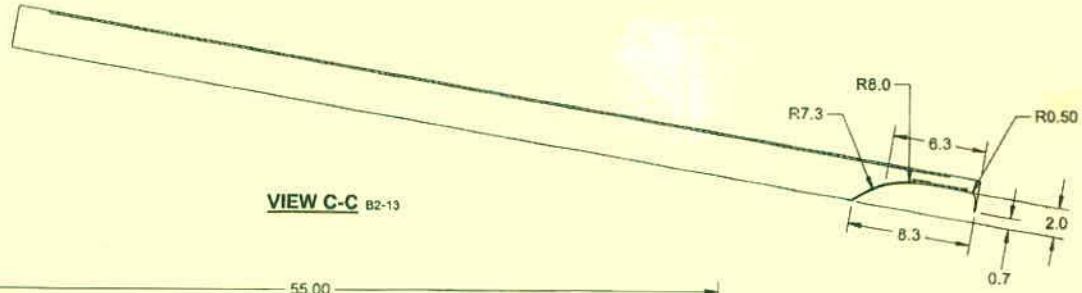
DART AEROSPACE LTD

Description:	Fwd Centre Panel LH	Work Order:	B110394
Inspection Drawing:	D4635	Rev: PE1	Part Number: D4635-1

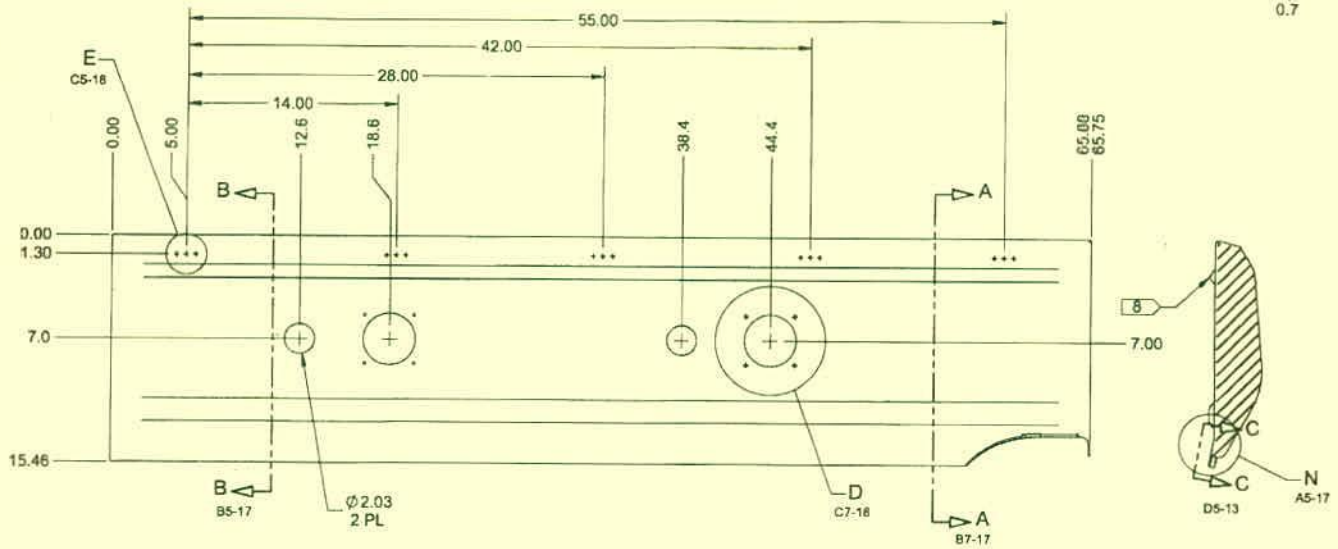
INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.30	+/- 005	1.30	✓			
7.00	"	7.00	✓			
15.46	"	15.46	✓			
14.00	"	14.00	✓			
28.00	"	28.00	✓			
55.00	"	55.00	✓			
12.6	"	12.6	✓			
18.6	"	18.6	✓			
38.4	"	38.4	✓			
44.4	"	44.4	✓			
Ø.203	"	Ø .204	✓			
5.00	"	5.00	✓			
Ø.191	"	0.192	✓			
Ø.350	"	0354	✓			
1.30	"	1.300	✓			
0.630	"	0.630	✓			
Ø 129	"	Ø 129	✓			
3.300	"	3.300	✓			
1.650	"	1.650	✓			

Measured by:	Checked By:	QC inspector:	Engineering Approval (*if necessary*):
Date DAS 27 9-89 14/1/16	Date	Date	Date



VIEW C-C B2-13



NOTES:
1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK
(REF DART SPEC MLEXS.093-F6006-07)
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 4.39 lbs
8) TEXTURE ON THIS SIDE
9) TRIM D4635-1 PER TOOL DT9839
10) THERMOFORM D4635-1 PER QSI 022 USING DT9847 TOOL
MIN. THICKNESS AFTER FORMING:
SHADED AREA = 0.040
RIDGES/EDGES = 0.060
ELSEWHERE = 0.070

D4635-1 LH, FWD CEILING PANEL

DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DC	DRAWING NO.	REV. E
MFG. APPR.		D4635	SHEET 13 OF 18
APPROVED		TITLE	SCALE
DE APPR.		OUTBOARD CEILING PANELS	NTS
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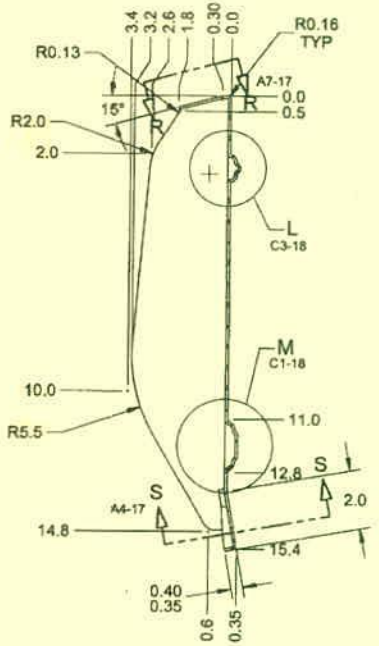
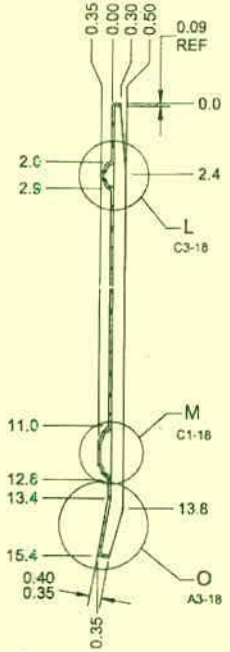


SECTION A-A
SECTION A'-A' OPPOSITE B3-13 B3-14
SCALE 2X



SECTION B-B B7-13 B7-14
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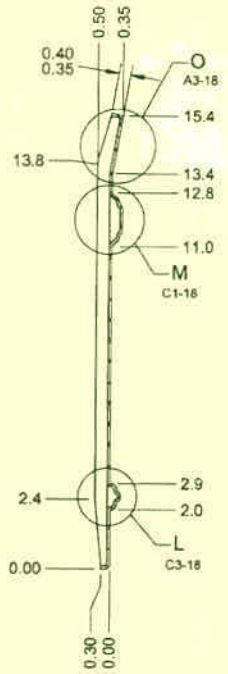

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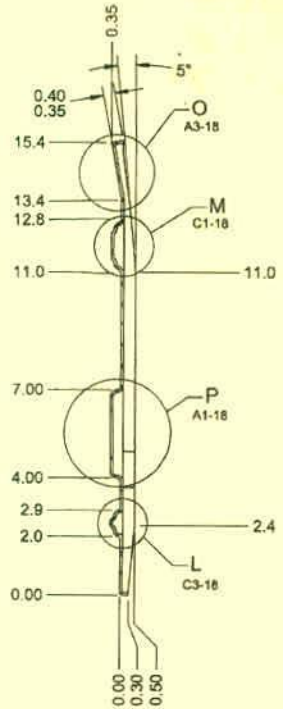

SECTION K-K C5-16
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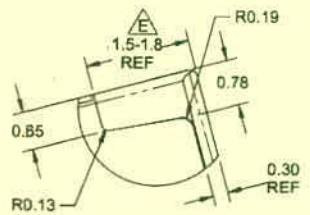
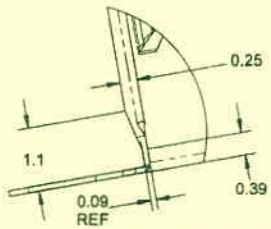


AUXILIARY VIEW R-R
SECTION R'-R' OPPOSITE D7-17
SCALE 2X



AUXILIARY VIEW S-S
SECTION S'-S' OPPOSITE B7-17
SCALE 2X

DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	DRAWING NO. REV. E
CHECKED	DC	D4635 SHEET 17 OF 18
MFG. APPR.		TITLE SCALE
APPROVED		OUTBOARD CEILING PANELS NTS
DE APPR.		
DATE	14.01.09	

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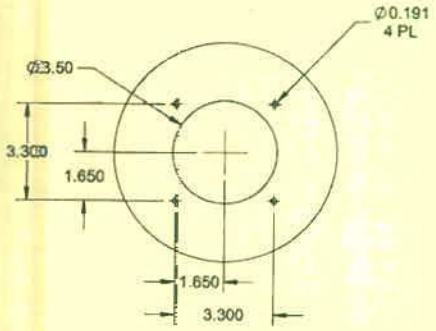
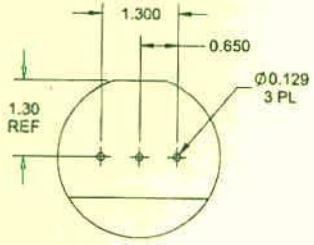


DETAIL D B4-13 B3-14 B5-15 B5-16
SCALE 2X



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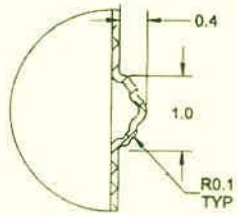

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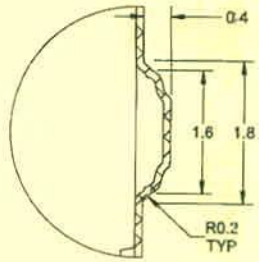

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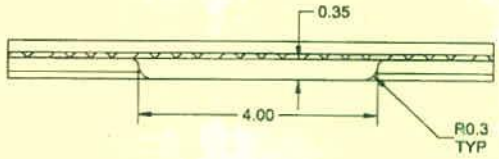

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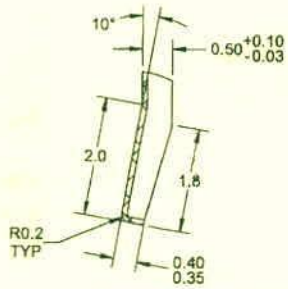

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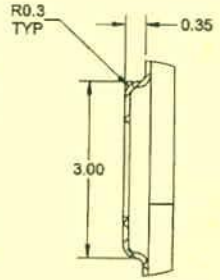

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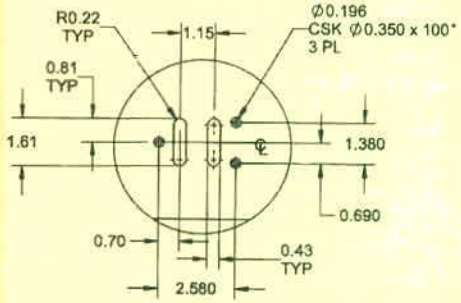

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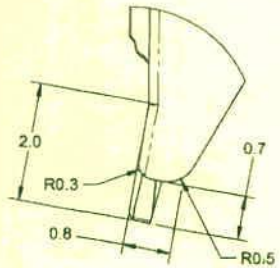

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APPROVED		OUTBOARD CEILING PANELS NTS
DE APPR.		
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